

Date: Wednesday, 04/02/2009 11:01:21 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG		
Job Number	: 45490					
Estimate Number	: 10512					
P.O. Number	:			Part Number	: D26511	
This Issue	: 04/02/2009		S.O. No. :	Drawing Number	: D2651 REV. B -BLUE	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 44342			Material	:	
Written By	:			Due Date	: 11/02/2009	
Checked & Approved By	:			Qty:	60 Um: Each	
Comment	: Est: A 02.04.15 New Issue NG					
	Est: B 05.12.12 added deburr EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
		Comment: Qty.: 0.0421 f(s)/Unit Total : 2.5263 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: M110532	
			09/02/07
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651	
		2- Deburr	09/02/07
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	09/02/07
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 09/02/08
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651	61x
			M-1 09/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	-	✓					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JS

04-02-10

(61)

7.0 SPRAY PAINTING

SPRAY PAINTING



Comment: spray painting

PRIME GREY

PAINT DELFLEET BLUE

CLEAR DELFLEET

ZT 09-02-23

(x61)

8.0 QC14

INSPECT SPRAY PAINT



ml 09 02 24

(61)

Comment: INSPECT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-A

JS 09-02-24

(61)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



09/02/24 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-24

DART AEROSPACE LTD	Work Order:	45490
Description: Plug	Part Number:	02651-1
Inspection Dwg:	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article □ Prototype

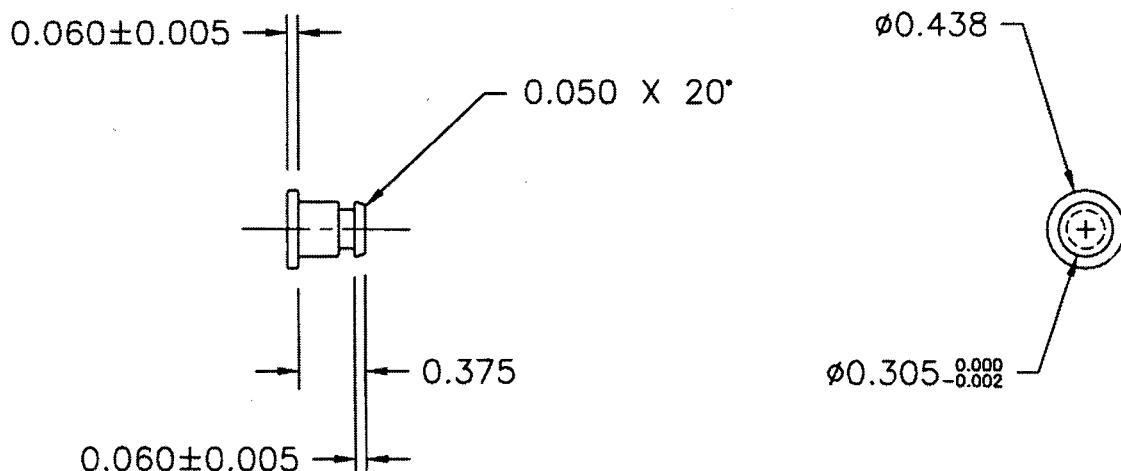
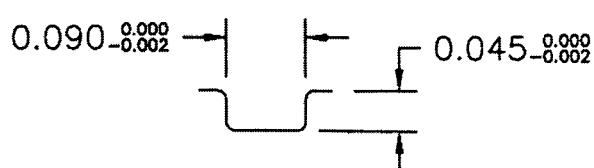
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/02/07	Date:	09/02/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

1

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED03.12.19 *[Signature]*D2651-1 PLUG:GROOVE DETAIL (SCALE 5:1)*W5490***D2651-1 PLUG**

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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